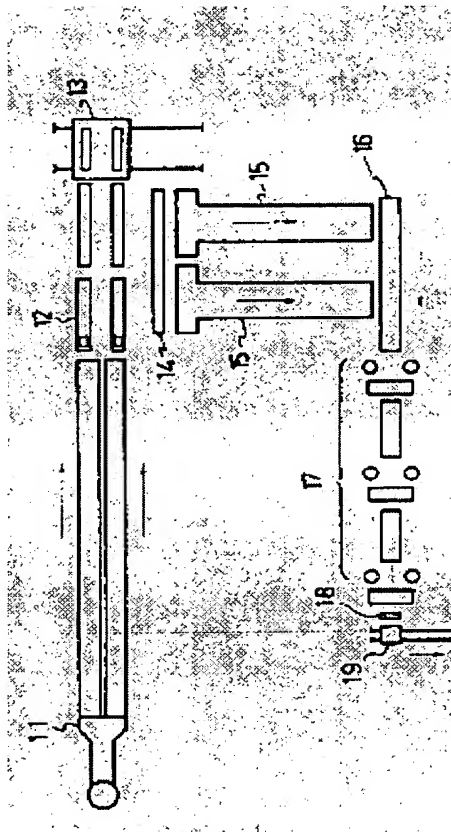


HOT ROLLING LINE FOR SLAB BY PLURAL CONTINUOUS CASTING INSTALLATIONS OF DIFFERENT KINDS

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Abstract of JP57146404

PURPOSE: To provide a titled line which permits selective hot rolling of the respective slabs from the plural continuous casting installations of the different kinds by combining an existing roller guide type continuous casting installation permitting production of slabs of many kinds of steels and a rotary belt type continuous casting installation of a high casting speed permitting of thin-walled slabs with a hot rolling line. **CONSTITUTION:** After the slab cast with an existing roller guide type continuous casting installation 11 is cut 12 to each prescribed length, the cut slabs are charged via a heating furnace inlet side table 14 into a heating furnace 15. The slabs are heated to about 1,200 deg.C in this furnace 15, after which they are charged into a roughing mill group 17, whereby they are molded to the sheet bars. Next, the leading ends of the sheet bars are cut 18, and immediately after this, they are coiled in a heat retaining coiler-un-coiler carriage 19, where the heat is maintained. On the other hand, the relatively thin-walled slab cast with a rotary belt type continuous casting installation 21 is cut 22 instantaneously to the sheet bars of the each prescribed length, thence the cut sheet bars are coiled through a heat retaining furnace 23 in an un-coiler carriage 24 where the heat is maintained. The carriage 19 or 24 is run to the inlet side of the finishing mills 32 in conformity with the schedules of the casting and hot rolling of the installations 11, 21, and



the sheet bars un-coiled from the carriage 19
or 24 are finish-rolled 32.

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